

628-032

Work Order ID 56507

February 25, 2010 11:47:16 AM

Page 1

Item ID: D2724-042

Accept

Revision ID:

Item Name: 206L Step Assembly

Start Date: 2/25/10 Start Qty: 2.00

Required Date: 3/05/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100



Large Fab

Large Fab

Large Fab

Memo

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

0.00

0.00

*10-02-26**2* *φ*

110



Large Fab

Large Fab

Large Fab

Memo

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by JigA/R AL ROD Batch: *M110130**M111311*

Grind end cap welds flush

0.00

0.00

*10-03-01**2* *φ*

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Page 2

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 2/25/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2

0

BE 10/03/01

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/03/01

2
24

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-03-01

2

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Page 3

Item ID: D2724-042

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Setup Start



Revision ID:

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Item Name: 206L Step Assembly

Start Date: 2/25/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1003-

②

160



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Inspect for foreign object per QSI 024

Weld Remainig end cap as per Dwg D2724

A/R AL ROD Batch: 1111311

Grind end plate flush.

10.03.02

2

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2

10.03.04

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Item ID: D2724-042

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Revision ID:

Item Name: 206L Step Assembly

Start Date: 2/25/10

Start Qty: 2.00

Required Date: 3/05/10

Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04

X2RH

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Jel 10/03/04

X2RH

X

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

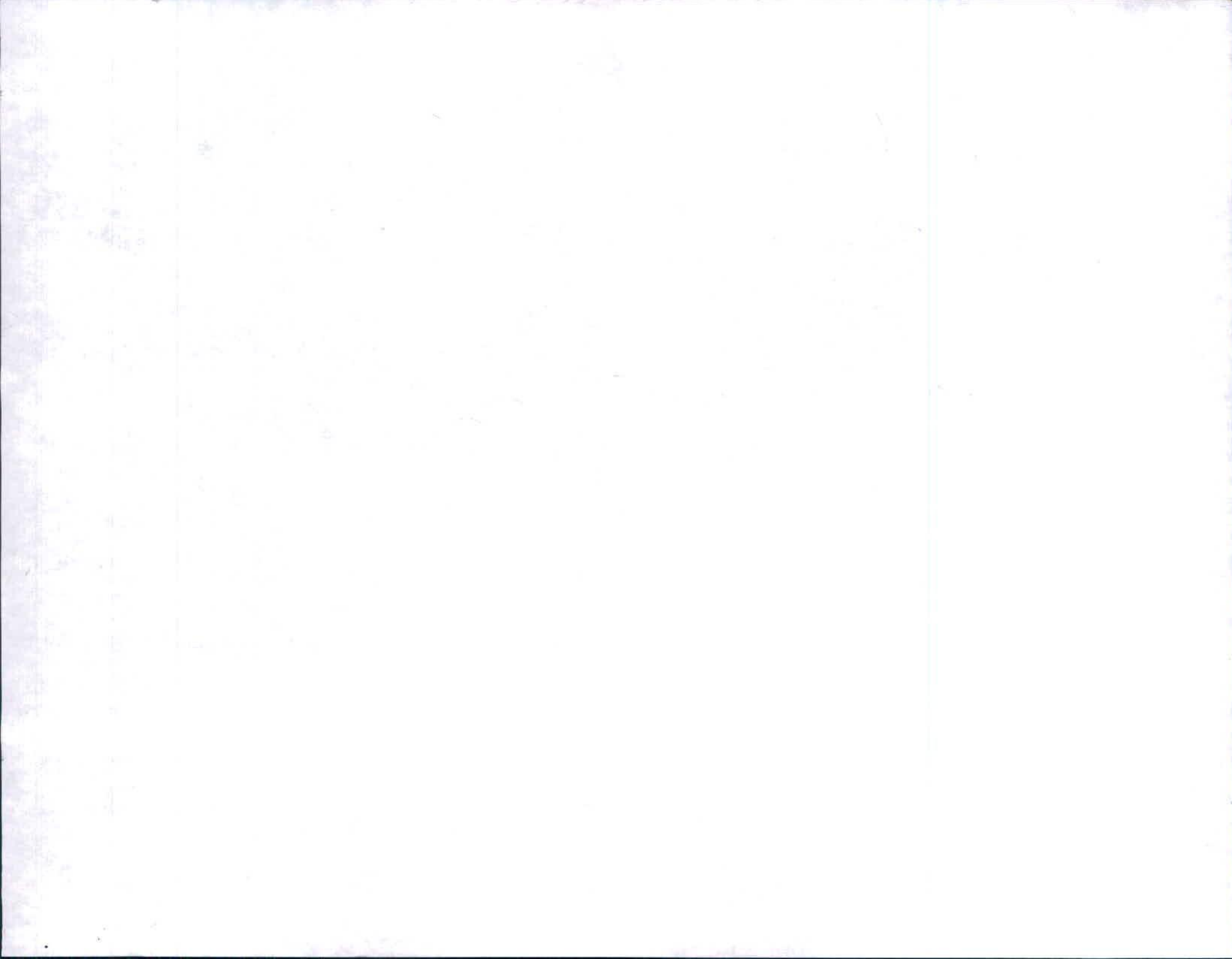
Powder Coating

M113170
START TIME: 8:45am
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:15am

-> Jel 10/03/05

X2RH

X



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Item ID: D2724-042

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Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 2/25/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/05/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00

BR 10-3-9

②.



QC

Memo

0.00

Quality Control

220

Wing Walk as per dwg QSI005 4.4 Batch M 1B462

0.00

BR 10-03-9

②.



HandFinish

Memo

Hand Finishing

230

QC3- Inspect Part Finish

0.00

Sidorog

+2



QC

Memo

0.00

Quality Control

RH

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Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 2/25/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/05/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

PP 55771

10-3-11 sf (24)



Packaging

Memo

0.00

Packaging

250

QC21-Final Inspection - Work Order Release

0.00

10/03/10 HJ



QC

Memo

0.00

Quality Control

mf 10-3-11

Picklist Print

February 25, 2010 11:47:14 AM

Page 1

Work Order ID: 56507

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Date: 2/25/10

Required Date: 3/05/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2734		Manufactured	No			110	Each	53.0000	2.0000			
-------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Step End Plate



10.03.02

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	4	
----	---	--

43535	2	
-------	---	--

48110	2	
-------	---	--

Main Warehouse

WA	49	
----	----	--

55014	49	
-------	----	--

D2734		Manufactured	No			160	Each	53.0000	2.0000			
-------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Step End Plate



2
10.03.01

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	4	
----	---	--

43535	2	
-------	---	--

48110	2	
-------	---	--

Main Warehouse

WA	49	
----	----	--

55014	49	
-------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 56507

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly


Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Start Date: 2/25/10

Required Date: 3/05/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3458-1  Step Mounting Plate		Manufactured	No			110	Each	34.0000	4.0000			

10.03.01

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
51239	3	
53408	31	

4

D3458-3

Step Mounting Plate


Manufactured No 110 Each 28.0000 4.0000



10.03.01

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	28	
53409	28	

4

D2622-120C

Step Extrusion

Manufactured No 100 Each 146.2400 2.0000



10.02.26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	146.24	
48612	3.12	
52026	20.12	
55214	123	

2

February 25, 2010 11:47:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

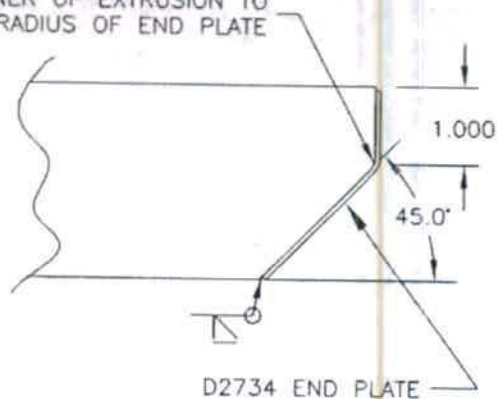


APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

1)	MAKE FROM EXTRUSION D2622	TYPICAL S
2)	WELD PER DART QSI 004	NOT
3)	FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4	
4)	ALL DIMENSIONS ARE IN INCHES	
5)	ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	

RELEASED
OS 11.14

DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	<i>AK</i>	APPROVED	<i>AK</i>	DRAWING NO.	REV. C
DATE	05.09.19			D2724	SHEET 1 OF 1
				TITLE	SCALE
				206L/407 STEP ASSEMBLY	NIS
A		97.12.04		NEW ISSUE	
B		98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES	
C		05.09.19		RE-DESIGN, ADD D3458-1/-3	

